



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G03451-3G-PO

Job Sheet 185406



Part No: RBW6205G03451-3G-PO **Job Qty:** 3 ea

Part Name: Bolt Guide Removal & Install



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/25/18

Job Tracking No:

Created By: Patrick Lussier

Due Date: 12/17/18

Description:

Type: Stock

Note: DWG RBW6205G03451-3G Rev.2B IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs		12/17/18	0.00	0.00	Purchasing		JAN 03 2019
110	Packaging	3 pcs		12/17/18	0.00	0.00	Packaging2		JAN 03 2019
120	QC	3 pcs		12/17/18	0.00	0.00	QC6		DAS8
130	Packaging	3 pcs		12/17/18	0.00	0.00	Packaging3		23-89
140	QC21-FG	3 Ea		12/17/18	0.00	0.00	QC21		9-89 JAN 08 2019

Part Op 100 - Issue P/O: 0413p7 MANUFACTURE RBW6205G03451-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G03451-3GP	Bolt Guide Removal & Install	3 (1 ea)	100-Purchasing	5141699

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G03451-3GP	3	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 10/25/18 1:59 PM dart.Lussier.Patrick

Container No: S141700



Part: RBW6205G03451-3G

Job No: 185406

Serial No/Batch: S141700

Revision: 2B

Inspector:

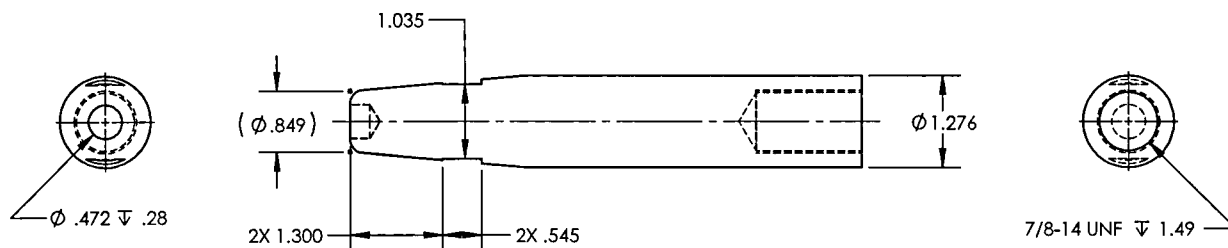
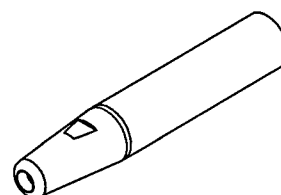
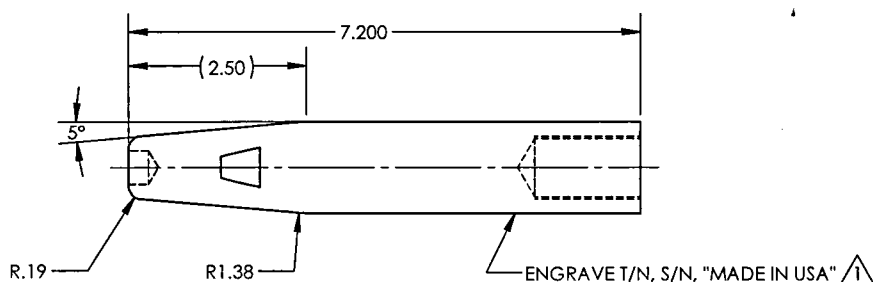
Exp Date:

Instructions:

Date: 01/03/19

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	ADDED 2.50 REF. DIMENSION.	9/24/2009	WP	GE
2	REMOVED ENGRAVING NOTE.	10/3/2009	WP	RW
2A	CHD WAS CLEAR HARD ANODIZING IS CLEAR ANODIZING.	10/27/2009	WP	GE
2B	SEPERATED TOOLS FROM KIT RBW6205G00331-3G. ADDED ENGRAVE NOTE AND BUFF NOTE. ADDED AW139 TO USED ON MODEL.	10/17/2013	CF5	RW



NOTE:

1 ENGRAVE LIGHTLY AND BUFF SMOOTH AFTER.

RED BARN MACHINE	
TITLE M/R BLADE RETENTION BOLT GUIDE	
DWG NO. RBW6205G03451-3G	REV 2B
MAT'L 6061	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .008 .XX ± .01 .X ± .1	REA TREAT FINISH CLEAR ANODIZE
FRACTIONS ± 1/32 ANGLES ± 5°	SPEC MIL-A-8625F, TYPE II, CLASS I
1. BREAK ALL SHARP EDGES .016 x 45° OR .016R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA AW139
SCALE 1:2	DATE 10/17/2013
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	BOLT GUIDE	6061	Ø1-3/8 X 7-3/8	1

[illegible]

 RED BARN MACHINE FUNCTION: USED TO REMOVE AND INSTALL THE MAIN ROTOR BLADE BOLTS.									
TITLE		M/R BLADE RETENTION BOLT							
		REM/INSTL TOOL KIT							
DWG NO.		RBW6205G00331-3G							
REV		2B							
MAYTL		DRAWN BY:		SMITH					
		APPROVED		<i>D. Mott</i>					
		UNLESS OTHERWISE SPECIFIED							
		DIMENSIONS ARE IN INCHES							
		FRACTIONS $\pm 1/32$							
		DECIMALS $\pm .005$							
		ANGLES $\pm .1^\circ$							
		TOLERANCES							
		FINISH							
		SPEC							
		1. BREAK ALL SHARP EDGES .016 x .44"							
		2. DIMENSIONAL LIMITS APPLY AFTER PLATING							
		USED ON MODEL							
		AGUSTA AWH139							
SCALE		1:2		DATE		10/17/2013		SHEET 1 OF 1	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041367
PO Date: 10/16/18
Due Date: 12/17/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Revise C1

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185295	RBW6005G01631-3GP			Dial Indicator Swash Plate Scissors Support REV A	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$1,150.00/pcs	\$2,300.00
Line Item Note SIOP													
2	185392	RBW1205G00231-3GP			Main Rotor Damper Oil Filling Adapter REV 2B	Firmed	-	12/17/18	3 pcs	0 pcs	3 pcs	\$1,000.00/pcs	\$3,000.00
Line Item Note SIOP													
3	185298	RBW6405G00332-3GP			Tail Rotor Pitch Control Adjustment Tool REV 5	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$1,500.00/pcs	\$1,500.00
Line Item Note SIOP													
4	185299	RBW6005G01531-3GP			Dial Indicator Main Rotor Damper Support REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$900.00/pcs	\$1,800.00
Line Item Note SIOP													
5	185300	RBW6405G00531-3GP			Tail Rotor Damper Length Adjustment Tool REV 1	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$700.00/pcs	\$1,400.00
Line Item Note SIOP													
6	185301	RBW6405G02131-3GP			Tail Rotor Blade Damper Attachment Bushing Removal REV D	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$500.00/pcs	\$1,000.00
Line Item Note SIOP													
7	185302	RBW6205G05951-3GP			RBW6205G05951-3GP REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$450.00/pcs	\$900.00
Line Item Note SIOP													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185303	RBW3205G00151-3GP			Main Landing Gear R&R Wrench REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$400.00/pcs	\$800.00
Line Item Note: SIOP 2X DEC 18 2018 ORDER 7393 22 Jan 2019													
9	185349	RBW6205G26631-3GP			Wrench, MR Scissor Retaining Nut Removal/Install REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$280.00/pcs	\$560.00
Line Item Note: SIOP 2X DEC 18 2018													
10	185352	RBW6205G26551-3GP			Main Rotor Scissor Locknut REV B	Firmed	-	12/17/18	2 Ea	0 Ea	2 Ea	\$175.00/Ea	\$350.00
Line Item Note: SIOP 2X DEC 17 2018													
11	185353	RBW109-3101-58-2P			Hammer, Aluminum, Blade Corrosion and Voids Detection REV 3	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$150.00/pcs	\$300.00
Line Item Note: SIOP 2X DEC 18 2018													
12	185354	RBW109-3101-58-1P			Hammer, Steel, Blade Corrosion and Voids Detection REV 3	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$150.00/pcs	\$150.00
Line Item Note: SIOP 1X DEC 18 2018													
13	185406	RBW6205G03451-3GP			Bolt Guide Removal & Install REV 2B	Firmed	-	12/17/18	3 Ea	0 Ea	3 Ea	\$625.00/Ea	\$1,875.00
Line Item Note: SUB ASSEMBLY OF RBW6205G00331-3G 3X JAN 03 2019 ORDER 7393 22 Jan 2018													
14	185407	RBW6205G08451-3GP			Puller Bolt Removal REV 2B	Firmed	-	12/17/18	3 Ea	0 Ea	3 Ea	\$625.00/Ea	\$1,875.00
Line Item Note: SUB ASSEMBLY OF RBW6205G00331-3G 3X DEC 17 2018 ORDER 7393 22 Jan 2018													
15	185423	RBW6205G08031-3GP			Main Rotor Flanged Bushing Removal Tool REV 2	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$1,125.00/Ea	\$1,125.00
Line Item Note: SUB ASSY FOR RBW6205G06231-3G 1X DEC 17 2018 ORDER 7393 22 Jan 2018													
16	185424	RBW6205G08131-3GP			Main Rotor Flanged Bushing Install Tool REV 2	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$1,125.00/Ea	\$1,125.00
Line Item Note: SUB ASSY FOR RBW6205G06231-3G 1X DEC 17 2018 ORDER 7393 22 Jan 2018													
17	185429	RBW6405G08832-3GP			Tail Rotor Bushing Install Tool As Per Dwg RBW6405G08832-3G Rev/ D	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$875.00/Ea	\$875.00
Line Item Note: SUB ASSY FOR RBW6405G08832-3G 1X DEC 18 2018 ORDER 7393 08 Jan 2019													

DAS
38
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
18		RBW6405G08732-3GP			Tail Rotor Bushing Removal Tool RBW6405G08732-3G Rev. E	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$875.00/Ea	\$875.00
Line Item Note SUB ASSY FOR RBW6405G08632-3G													
19	185430	RBW6205G10451-3GP			Threaded Rod	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
20	185431	RBW6205G10551-3GP			Hammer	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
21	185432	RBW6205G10351-3GP			Guide REV 1	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
22	185433	RBW6205G10251-3GP			Threaded Rod	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
23	185434	RBW6205G10151-3GP			Pusher REV 1	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
24	185435	RBW6205G10651-3GP			Stop	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
25	185461	RBW6305G26631-3G-1P			Pin REV 2	Firmed	-	12/17/18	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
Line Item Note SUB ASSY FOR RBW6305G26631-3G													
26	185462	RBW6305G26631-3G-3P			Handle REV 2	Firmed	-	12/17/18	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
Line Item Note SUB ASSY FOR RBW6305G26631-3G													
												Grand Total:	\$23,959.98

Order Notes

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

**METAL TECHNOLOGY INC.****www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956**

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24471
Shipment Date: 02-Jan-2019
Ship Via: Pick up at METEC
Order Number: 3096
Order Date: 10/17/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041367 ✓
Terms: Net 60 Days

----- Quantity -----									Job
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Number</u>	
14	3	3 ✓	0	0	EA	DART-RBW6205G03451-3G M/R BLADE RETENSION BOLT GUIDE	2B	3096-14	DAE 38 9-85
20	1	1 ✓	0	0	EA	DART-RBW6205G10451-3GP Threaded Rod	-	3096-20	
22	1	1 ✓	0	0	EA	DART-RBW6205G10351-3GP Guide	1	3096-22	
23	1	1 ✓	0	0	EA	DART-RBW6205G10251-3GP Threaded Rod	-	3096-23	
24	1	1 ✓	0	0	EA	DART-RBW6205G10151-3GP Pusher	1	3096-24	

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By _____

Page 1 of 1



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number	
3 ✓	DART-RBW6205G03451- 3G	M/R BLADE RETENSION BOLT GUIDE	2B	41367 ✓	DAS 38 9-89
1 ✓	DART-RBW6205G10451- 3GP	THREADED ROD	-	41367 ✓	
1 ✓	DART-RBW6205G10351- 3GP	GUIDE	1	41367 ✓	
1 ✓	DART-RBW6205G10251- 3GP	THREADED ROD	-	41367 ✓	
1 ✓	DART-RBW6205G10151- 3GP	PUSHER	1	41367 ✓	

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

George Theoret